

Date: Thursday, 02/04/2009 2:29:28 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR SUPPORT KIT
Job Number : 46899
Estimate Number : 12112
P.O. Number :
This Issue : 02/04/2009 S.O. No. :
Prsht Rev. : NC Part Number : D412698015
First Issue : // Type : MACHINED PARTS Drawing Number : IIN D412-698 REVD
Previous Run : 46458 Drawing Revision : D
Written By : Due Date : 14/04/2009 Qty: 40 Um: Each
Checked & Approved By : JLD 09.04.03
Comment : Est Rev:C Removed Manufacturing 06-01-25 JLM
Est Rev:D change to rev D ECN 1104 08-01-28 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D32001 Door Post Block



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3200-1 Door Post Block 45666

4.0 D32003 Door Wedge



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3200-3 Door Wedge B43130x10 B46520x4

5.0 D32011 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3200-1 Door Post Block B46011x6 B45702x8

Need to fix Batches.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:29:29 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SUPPORT KIT

Job Number: 46899

Part Number: D412698015

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D3201-1 Doubler

6.0

D32013

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-3 Angle

B43602

7.0

D32014

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-4 Angle

B36757x1 B460012xp

8.0

AN960JD10L

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~120.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD10L Washer

M109632

9.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~120.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L3 Nut (or -3)

M110399

10.0

MS24693S277

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~120.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS24693-S277 Screw

M110998

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:29:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SUPPORT KIT

Job Number: 46899

Part Number: D412698015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Log 100% (7)
Separated kits x (7)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-015

Location: 22

PPP Rev: A

9/4/8

SD

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)

Dag 10/4/09

Job Completion



MF
09-04-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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 NO. 46879

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Revision: E
 Date: 08.05.01

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

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 NO. 46818

Date: Tuesday, 07/04/2009 10:05:03 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR SUPPORT KIT
Job Number : 46899	
Estimate Number : 12112	
P.O. Number :	Part Number : D412698015
This Issue : 07/04/2009 S.O. No. :	Drawing Number : IIN D412-698 REVD
Prsht Rev. : NC	Project Number : N/A
First Issue : 02/04/2009 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 46458	Material :
Written By :	Due Date : 14/04/2009 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est Rev:C Removed Manufacturing 06-01-25 JLM Est Rev:D change to rev D ECN 1104 08-01-28 DD	

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC

DOCUMENT CONTROL



JUD 09.04.07



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

/ 5 09/04/07

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Job Completion

